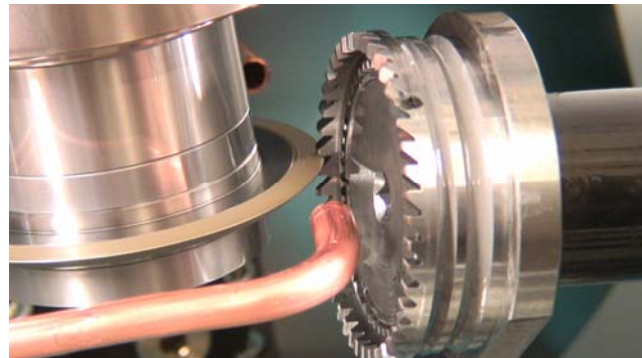






## Special gear

### A40-900

This special gear is part of an airplane engine.  
Dressing of the grinding wheel with CNC-dressing unit, grinding of two very precise angle following a profil dxf.



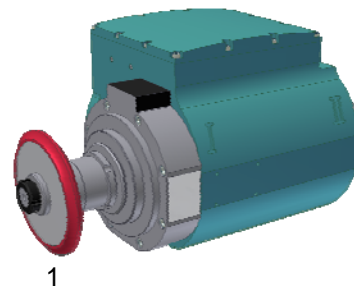
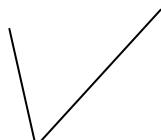
### 1. Cycletime for Production

Specifications Diameter 130 mm, Z5				
Operations				
Feed [mm/Min]	2000	150	150	
Power [kW]		1	1	
Cutting feed [m/s]		32	24	
Used wheels				1
Grinding time [s]	20	120	360	
Total cycle time	8 Min 20			

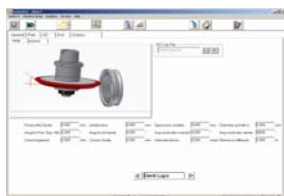
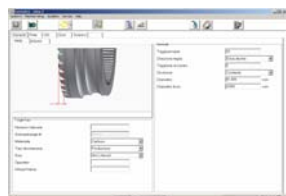
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1 Ø36 DXF Conventional



### 3. Machine and Software Requirements



Machines: 5 axes CNC grinders : NORMA CFG  
Control: Fanuc 160i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 5, DXQ  
Engineer: Di, 01.04.2009

[www.schneeberger.ch](http://www.schneeberger.ch)

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